

Date: Wednesday, 18/03/2009 7:12:34 AM  
User: Melanie Fauteux

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-ACCESS STEP RH (FOLDING)
Job Number	: 46549		
Estimate Number	: 12568		
P.O. Number	:	Part Number	: D412630034
This Issue	: 18/03/2009 S.O. No. :	Drawing Number	: IIN D412-630
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: M
Previous Run	: 46456	Material	:
Written By	:	Due Date	: 30/03/2009 Qty: 4 Um: Each
Checked & Approved By	: <u>MF 09-03-18</u>		
Comment	: Est. Rev:A New Issue 06-11-08 JLM est rev B ecn1019, added D2807-041 EC verified by:DD Est RevC 09-03-02 as per rev.m DD verifeid by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL  
Photocopy bluefile & create labels per PPP D412-630-034 CHG003

09/04/17

2.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Clevis  
Pick:

Qty	Part Number	Description	Batch
1	D2012-107	Clevis	<u>B45074</u>

9/3/31

(42)

SP

3.0	D2803042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bracket Assembly  
Pick:

Qty	Part Number	Description	Batch
1	D2803-042	Bracket Assembly RH	<u>B46330</u>

09/04/14

4.0	D2804042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bracket Assembly  
Pick:

Qty	Part Number	Description	Batch
1	D2804-042	Bracket Assembly RH	<u>46313</u>

9/4/14

(42)

SP

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Seq. #:

Machine Or Operation:

Description :

5.0

D2807041

Door prop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Support Prop

Batch: B44858

50

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

46332

50

7.0

D3562042

Step Assembly, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-042	Step Weldment RH

Batch

B46552

50

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

42180

12 4  
46345

50

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

M109148

9/3/31

(46)

50

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN8C16

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

②  
M102736

6  
M105969

SP

11.0

AN310C8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M109148

SP

12.0

MS24665302

Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M106763

SP

13.0

NAS1515H3

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M109268

SP

14.0

NAS1515H5L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M108964

9/3/31

SP

4K

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

1111275

50

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

1110562

50

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

1111390

9/13/11

50

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: 1109929

COAT exposed HARDWARE WITH LPS PROCYON .

A/R LPS PROCYON

BATCH:

1104251

8/09/04/14

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/04/15

4 RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2

D2806-1

Bushing

42174

SS 09/04/14 (X)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bushing

Pick: Packing Kit

Qty Part Number

Description

Batch

2

D2806-3

Bushing

42175

SS 09/04/14 (X)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Strut

Pick: Packing Kit

Qty Part Number

Description

Batch

1

D2810-5

Strut

346041

9/4/14

SS

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Spacer

Pick: Packing Kit

Qty Part Number

Description

Batch

2

D3396-1

Spacer

B11670

SS 09/04/14 (X)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1

AN4C6A

Bolt

M109147

SS 09/04/14 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 46549

Part Number: D412630034

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN4C10A

Bolt

M106302

SS 09/04/14 (x4)

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN4C15A

Bolt

M110155x5  
M107082x3

SS 09/04/14 (x4)

28.0

AN44C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN44-C7A

Eyebolt

M100446

SS 09/04/14 (x4)

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN5C15A

Bolt

M109148

SS 09/04/14 (x4)

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H4

Washer

M11294 x12  
M109267 x16

SS 09/04/14 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 46549

Part Number: D412630034

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	NAS1515H5	Washer
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Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	M109430

SS 09/04/14 (x4)

32.0	MS210434	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	M111177

SS 09/04/14 (x4)

33.0	MS210435	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	M109053

SS 09/04/14 (x4)

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/04/17 (x4RH)

35.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-034

Location:

PPP Rev:

9/14/17

(4x)

SS

36.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

SS 09/04/20

Job Completion



mf 09-04-18

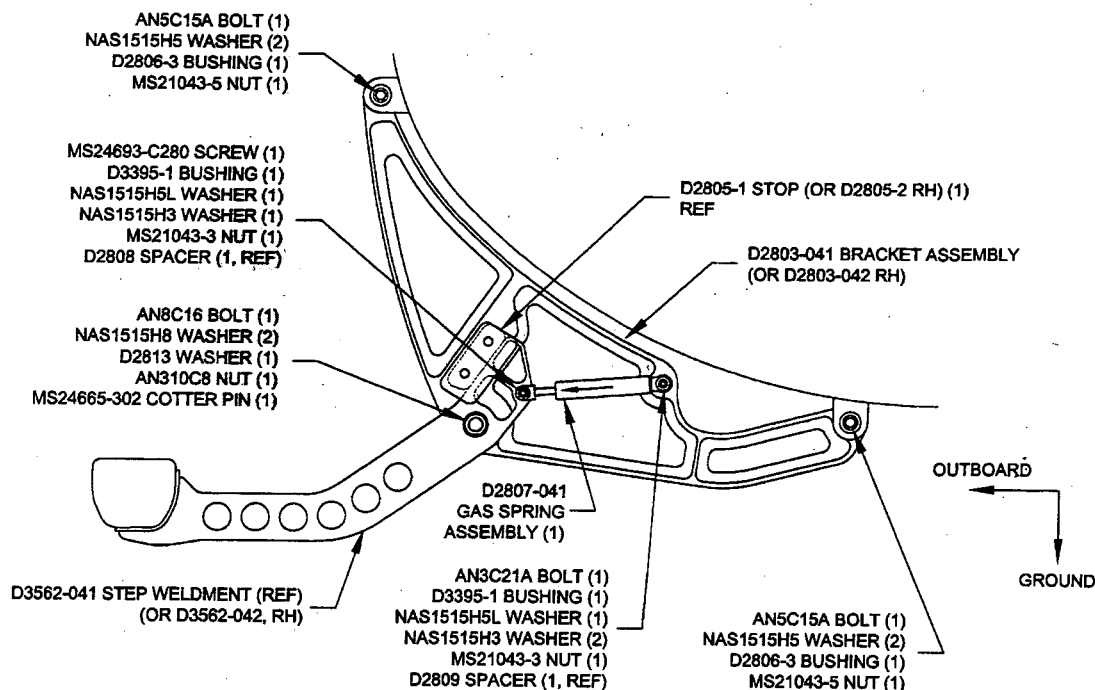
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

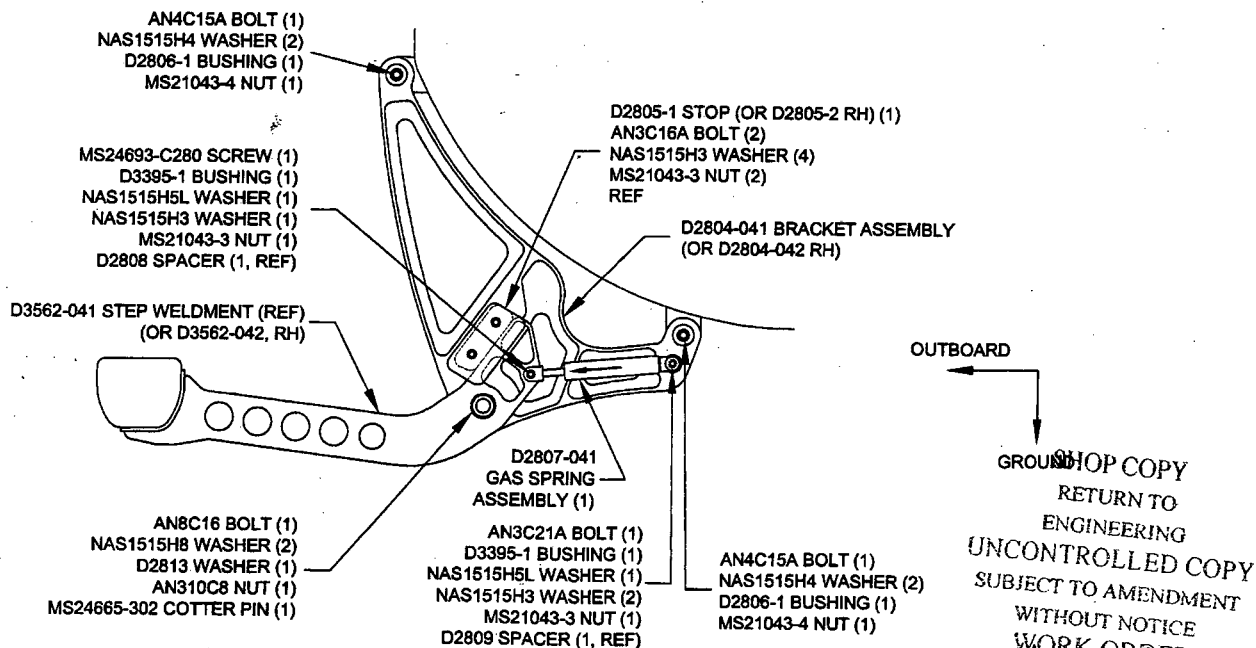
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**D412-630-033/-034 Heli-Access-Step™ Installation**

**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)



**FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation**  
(View rotated 90° CW)

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Revision: **M**  
Date: 08.12.12

